

Date: Thursday, 21/06/2007 2:57:31 PM
User: Linda Lacelle

Process Sheet

Split 10-31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOW RING
Job Number : 33099
Estimate Number : 10396
P.O. Number :
This Issue : 21/06/2007 S.O. No. :
Prsht Rev. : NC Part Number : D2968041
First Issue : / / Type : MACHINED PARTS Drawing Number : D2968
Previous Run : 31957 Project Number : N/A
Material : B1
Written By : Due Date : 10/07/2007 Qty: 20 Um: Each
Checked & Approved By :
Comment : Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2968-1 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-041

Batch: 102226

FC 07/06/23 20

2.0 D29681 Stem



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Stem 130302

FC 07/06/23 (20)

3.0 D29685 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Ring 132503B

FC 07/06/23 (20)

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/06/25 (20)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/06/25 (20)

6.0 OUTSIDE SERV.30 OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 4038

Description: D2968-041 to heat treat to ultimate tensile strength 125ksi as per Dwg D2968

C 107/06/25

(20)

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 21/06/2007 2:57:32 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 33099

Part Number: D2968041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Conformity sheet required

Issue P/O: 4039

CD 07/06/25

Cad Plate per QQ-P-416F Class I Type II

(20)

Conformity sheet required

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

CD 07/07/25 (20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT CAD PLATE

En 07/07/26 (20) gauts

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DO NOT POWDER COAT THREADS

n 105 068.

FX

07/07/30 (20)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FA-10-30 (15)

(PTO)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 464

7/10/01

sq

(75x)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.01

HA

Job Completion



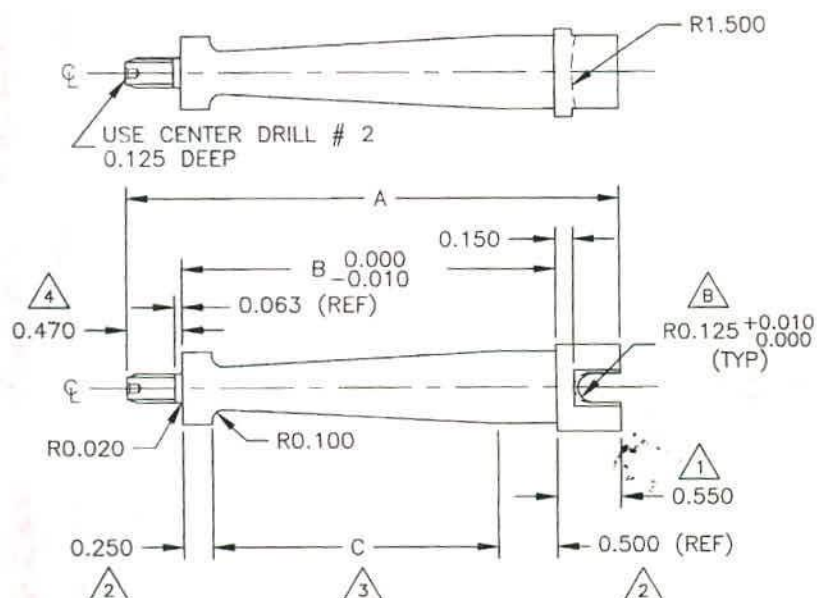
In stock

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2968-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 09/11/01
 QA: N/C Closed: _____ Date: _____

NCR: <u>33099</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10	10.0	5 parts, the end-plating is QAS. ly chipped off after Powder coating. See NCR 246.	<u>AS1W2</u>	- split w/o, to proceed with NCR 246, and return to Mance, for a Qty of 5 parts. to go on-2 w/o, and Qty 15 on this w/o.	<u>AS1W2</u> 07-10-30	<u>AS1W2</u> 07-11-31	<u>AS1W2</u> 07-10-30	<u>AS1W2</u> 07-10-30

NOTE: Date & initial all entries



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ 0.750 O.D.

△ 0.625 O.D.

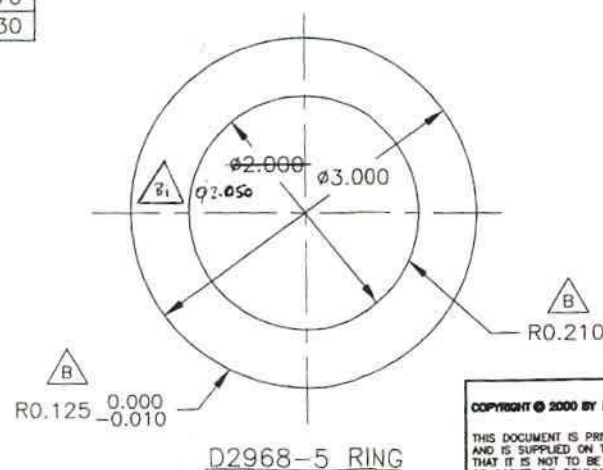
△ MACHINE UNIFORM TAPER FROM 0.363 O.D. TO 0.625 O.D.

△ 1/4-28 UNF THREAD WITH 0.063 GRIP
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968-5 RING:

MATERIAL AISI 4130

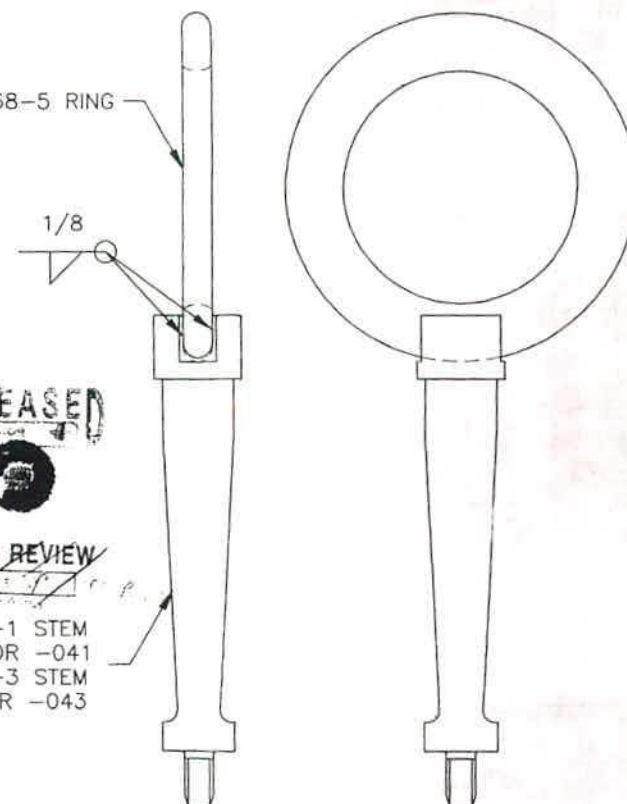
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED

UNDER REVIEW

USE 2968-1 STEM
FOR -041
USE 2968-3 STEM
FOR -043



D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI

FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD.

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2968
DATE	00.05.31	TITLE TOW RING

REV. B
SHEET 1 OF 1

1:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

MANCO DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1B6
Tél.: 514-355-7867
Fax: 514-355-8750

CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE

17035

Dart Aerospace LTD
Client / Customer

1 Lot of pieces
de la pièce / part

P04039
Votre # de commande / Your purchase order #

105061
Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector	<u>Renaud</u>	Date, équipe / Date, shift	<u>22/07/07</u>
Placage / Plating	<u>QQP-416 CLASS 1 Type FF</u>		
Quantité totale / Total quantity	<u>1 Lot</u>	Quantité inspectée / Inspected quantity	<u>1 Lot</u>
Adhésion / Adhesion	<u>Good</u>		
Épaisseur / Thickness	L.C.D.	H.C.D.	Moy. / aver. <u>0.0005</u>
Coussins, taches / Leach, spots	<u>no</u>	Rugosité / Roughness	<u>no</u>
Quantité approuvée / Approved quantity	<u>1 Lot</u>	Quantité rejetée / Rejected quantity	<u>—</u>

Commentaires / Comments

D2768-041-B33099 = 30 Pcs
D2768-043-B32503 = 30 Pcs

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

**MANCO
DOMPLEX**